



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

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D119-796-241TRN
Job Sheet 178339



Part No: D119-796-241TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 6/5/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV J IPP REV A RQ 14/05/27 VERIFIED BY DD IPP REV:B 16.05.04 AS PER DWG REV.I DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/5/18	0.00	0.00	Start Up Crosstubes-1		M.D.
100	Mori Seiki	1 pcs		6/5/18	1.77	1.72	Mori Seiki TL-40		M.D.
110	QC	1 pcs		6/5/18	0.00	0.00	QC2-1		M.D.
120	Mori Seiki	1 pcs		6/5/18	0.00	1.72	Mori Seiki TL-40		M.D.
130	QC	1 pcs		6/5/18	0.00	0.00	QC2-1		M.D.
140	QC	1 pcs		6/5/18	0.00	0.00	QC8		M.D.
145	Crosstubes	1 pcs		6/5/18	0.00	0.45	Crosstubes-1		GP/18-06-06
150	HandFXtube	1 pcs		6/5/18	0.00	0.33	Crosstubes-3		GP/18-06-07
160	QC	1 pcs		6/5/18	0.00	0.00	QC7-1		GP/18-06-07
170	Packaging	1 pcs		6/5/18	0.00	0.00	Packaging3-1		GP/18-06-07
180	QC21-FG	1 Ea		6/5/18	0.00	0.00	QC21		GP/18-06-07

Part Op 100 - 1-Fill tube with sand & install plugs on both ends as per Folio FB298 2-Turn first side as per Folio FB298
Descriptions: 120 - 1-Turn second side as per Folio FB298

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6023-106	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

B150731

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6023-106	1	39	0

Part Specifications

Specifications could not be found.



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Container No: S078261



Part: D119-796-241TRN

Job No: 178339

Serial No/Batch: S078261

Revision:

Inspector:

Exp Date: 06/05/2018

Instructions:

Date: 06/05/18

(4)

DART AEROSPACE LTD	Work Order:	
Description: Crosstube Assembly (AW119 MKII Aft)	Part Number:	D119-796-241TRN
Inspection Dwg: D119-796-241 Rev: J		Page 1 of 2

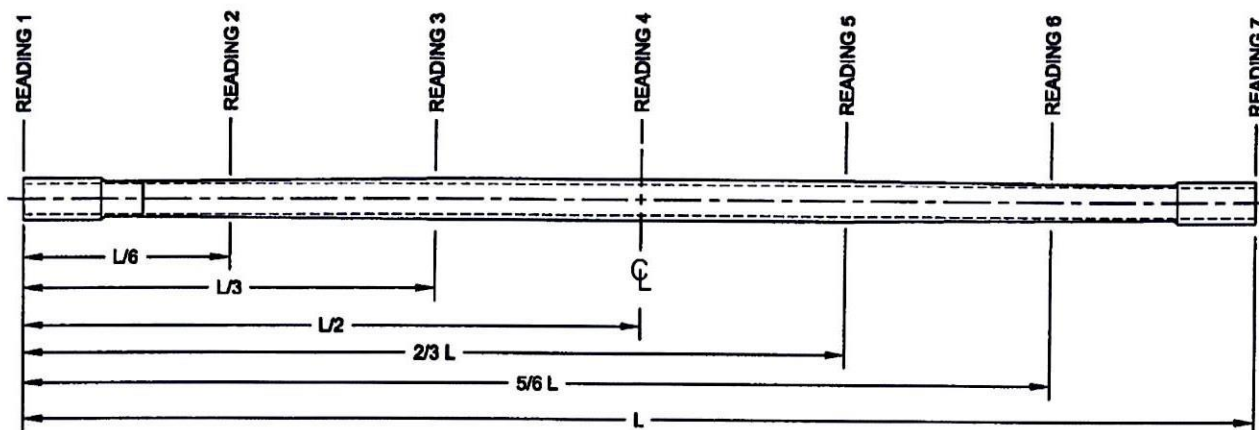
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	5.88	+/-0.030	5.882	✓		Vern 08	
	2.516	+0.005/-0.000	2.521	✓		BLM3"04	
	2.626	+0.005/-0.000	2.631	✓		"	
	2.627	+0.005/-0.000	2.632	✓		"	
	2.798	+0.005/-0.000	2.803	✓		"	
	2.799	+0.005/-0.000	2.803	✓		BLM3"04	
	2.989	+0.005/-0.000	2.992	✓		"	
	3.191	+0.005/-0.000	3.196	✓		BLM4"05	
	3.200	+0.005/-0.000	3.205	✓		Vern 08	
SIDE B	5.88	+/-0.030	5.882	✓		Vern 08	
	2.516	+0.005/-0.000	2.521	✓		BLM3"04	
	2.626	+0.005/-0.000	2.631	✓		"	
	2.627	+0.005/-0.000	2.632	✓		"	
	2.798	+0.005/-0.000	2.803	✓		"	
	2.799	+0.005/-0.000	2.804	✓		BLM3"04	
	2.989	+0.005/-0.000	2.993	✓		"	
	3.191	+0.005/-0.000	3.196	✓		BLM4"05	
	3.200	+0.005/-0.000	3.205	✓		Vern 08	
	105.71	+/-0.020	105.71	✓		Tape	

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Description: Crosstube Assembly (AW119 MKII Aft)	Part Number:	D119-796-241TRN
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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.130	.135	.129	.123	.012	0.030"
READING 2 L= 17.62	.200	.215	.206	.188	.027	
READING 3 L= 35.24	.300	.315	.306	.292	.023	
READING 4 L= 52.86	.492	.499	.476	.476	.023	0.063"
READING 5 L= 70.47	.299	.315	.308	.292	.023	
READING 6 L= 88.09	.197	.208	.207	.197	.011	
READING 7 L= 105.71	.132	.140	.126	.117	.023	

Calibration Result

Actual Block Thickness: 100-500

Sitescan 250 Measured Thickness: 100-500

Measured by:	<u>M. D. PMP</u>
Date:	<u>2018-06-05</u>

Audited by:	
Date:	

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	14.09.18	New Issue (P/O D119-796-201)	KJ	
B	15.03.12	Dimensions updated per Dwg Rev F	KJ	
C	15.04.14	Tolerance dimensions revised on Wall Thickness table	KJ	
D	15.05.14	Tolerances revised per Dwg Rev G	KJ	
E	15.09.09	Dwg Rev updated	KJ	
F	16.05.27	Dwg Rev updated	KJ	
G	17.07.12	Dwg Rev updated	KJ	

